

Work Order ID 53485

November 6, 2009 8:43:03 AM



Page 1

Item ID: D1049

Revision ID: A

Item Name: Saddle

Start Date: 06/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *PL*

Date: *09-11-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D1049	Rev A								

100



Shear

Shear

SHEAR Saw

Memo

Cut Blanks: 2.000" long

M110829 6061 T6 .375 x .750

0.00

0.00

DJP 09/11/19

20

P70

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per folio FA217 & Dwg D1049
2-Deburr

0.00

0.00

DJP 09/11/19

20

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB


Memo

0.00

0.00

DJP 09/11/19

20

W/O: 53485		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.11.20	100	OK TO USE 6061-T6				 09.11.20 PC OK 1042	

Part No: D 1049 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53485

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Item ID: D1049

Revision ID: A

Item Name: Saddle

Start Date: 06/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

SP 09/11/19

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

09/11/23

(20x)

φ

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

START TIME: 8:45
OVEN TEMPERATURE: 320°
FINISH TIME: 9:15

Powdercoat. (20)

Work Order ID 53485

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Item ID: D1049

Revision ID: A

Item Name: Saddle

Start Date: 06/11/2009 Start Qty: 20.00

Required Date: 13/11/2009 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

= 7 m. h 09/11/24

170



Packaging

Packaging

Identify as per dwg & Stock Location: 2

Memo

0.00

0.00

9/11/24 (200) SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/11/25 JF
Pl 09-11-24
(20)

Picklist Print

Page 1

November 6, 2009 8:43:07 AM

Work Order ID: 53485



Parent Item: D1049RevA



Parent Item Name: Saddle

Start Date: 06/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T5.000W.125		Purchased	No				f	20.7400	7.5200			



6061-T6 Tube 5.00 X .125W

N/A
See Davey A.H.
Jan 10/09 11:20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

20.74

102019

5.24

105532

3.5

111699

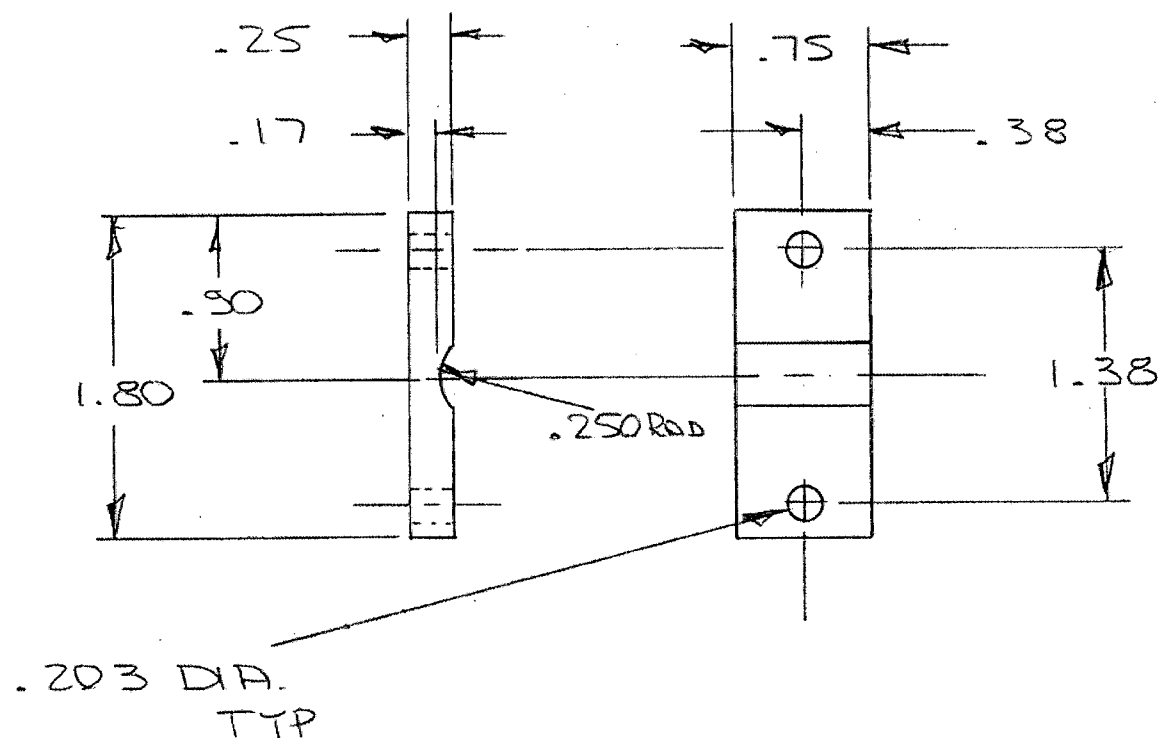
12

6061T6 375x.75M 110829

3.33(F)

DIP 09/11/09

RELEASED
97/09/02 BW



MATERIAL : S052-H32
OR 6061-T6
FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 573		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN			BASIC CODE	DA, DASH NO. R=HEAD REAR SIDE F=HEAD FRA SIDE	CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D=HOLE DIGIT=NO OF SHEETS C=COUNTERSINK	LENGTH DASH NO. W=SPOTWELD	DRAWN	DATE			
	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL LIMITS 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL — 8 — 32 X 2 5. HOLES PER AND 10247		1. TOLERANCES — .001 & .0030 2. ANGLES .001 & .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL MFC CENTRE LINES .005		DESIGN	1992			
DESCRIPTION OF CHANGE			BASIC CODES 8-H-M25047040 88-H-M25047040		STRESS		TITLE SADDLE		
					CHECKED		CODE	DWG NO D1049	REV
REPORT ALL DISCREPANCIES — DO NOT SCALE					CLIENT		SCALE	SHT	OF

Date: Tuesday, 17/02/2009 10:18:10 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BLOCK
Job Number : 45810	
Estimate Number : 10324	
P.O. Number :	Part Number : D1049
This Issue : 17/02/2009 S.O. No. :	Drawing Number : D1049 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39919	Material :
Written By :	Due Date : 03/03/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JUL 09-02-17</u>	
Comment : Est RevC 02.04.10 Re-format NG	

REFERENCE ONLY

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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Comment: Qty.: 0.1749 f(s)/Unit Total: 3.4986 f(s)

Material: 6061-T6 bar .750 wide x .250 thick.

Batch M110829 .375X.750 X 4 parts

50.575 x .750

M18237 X 16 parts

88 09/02/19

2.0	SHEAR	SHEAR
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Comment: SHEAR

Cut Blanks: 2.000" long

88 09/02/19

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

9th 09/02/25

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9th 09/02/25

(20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 09/02/25

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		-15.4792						

NOTE: Date & initial all entries